

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024909**Date Inspected:** 18-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:** **Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:** **Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:** **Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:** **Yes No N/A****Delayed / Cancelled:** **Yes No N/A****Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Post Blast Inspection

QA performed visual inspection (VT) of exterior welds/surfaces on OBG Segments 13AW, 13BW, PP119~PP12 CB side, Blast Shop 4. Caltrans QA observed excessive weld gap at 13BW, interior longitudinal diaphragm connection plate to floor beam flange at PP121.5 (East), weld SEG3014E-002 and missing weld at 13AW, interior deck plate stiffener to deck plate diaphragm at PP120 (CB side), weld SEG3013V-097. Caltrans QA informed ABF QC inspector Kelvin Cheung of the inspection results and informed him that a QA Incident Report is being generated for the excessive weld gap and missing weld. See QUALITY ASSURANCE – POST BLAST WELD REPAIR REPORT, dated 06-18-11 for additional information and Quality Assurance-Incident, dated 06-18-11 for further information.

The following digital pictures illustrate excessive weld gap.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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Summary of Conversations:

“As noted within the contents of this report.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
